



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3785-3

Job Sheet 175018



Part No: D3785-3

Job Qty: 6 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/26/18

Job Tracking No:

Due Date: 4/6/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A 08-05-01 new issue DD verified by:EC IPP Rev:B 09-01-09 rev.B as per dwg DD verified by:ec IPP Rev:C 10.04.27 as per dwg revE DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	4/5/18	4/5/18	0.00	0.00	Start Up Waterjet		SC 18/03/27
100	Waterjet	6 pcs	4/5/18	4/5/18	0.00	0.43	Waterjet1		SC 18/03/27
110	QC	6 pcs	4/5/18	4/5/18	0.00	0.00	QC2 Waterjet-2		SC 18/03/27
120	QC	6 pcs	4/5/18	4/5/18	0.00	0.00	QC8-3		23
130	Brake NC	6 pcs	4/5/18	4/5/18	0.00	0.72	Brake NC 2		DAS 38
140	QC	6 pcs	4/5/18	4/5/18	0.00	0.00	QC5		38
150	Small Fab	6 pcs	4/5/18	4/5/18	0.00	0.67	Small Fab-5		9-88 DAS
160	QC	6 pcs	4/5/18	4/5/18	0.00	0.00	QC5		38
170	HandFinish	6 pcs	4/5/18	4/5/18	0.00	0.33	HandFinish1		SA 18-04-08
190	Powdercoat	6 pcs	4/6/18	4/6/18	0.00	0.12	Powdercoat3		BR 18-4-9
200	QC	6 pcs	4/6/18	4/6/18	0.00	0.00	QC3		38
210	Packaging	6 pcs	4/6/18	4/6/18	0.00	0.00	Packaging3-1		APR 9 2018
220	QC21-SA	6 Ea	4/6/18	4/6/18	0.00	0.00	QC21		21 APR 09 2018

Part Op 100 - 1-Cut as per Dwg D3785 Dwg Rev: E Prog Rev: E ****grain direction 45 degree**** 2- Debur if Descriptions: necessary

150 - 1-counter sink holes as per dwg D3785

190 - START TIME: 10:00 OVEN TEMPERATURE: 320° FINISH TIME: 11:20

M 136370

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	1.7892 sf (.2982 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	2	161	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order:	175018
Description: Bracket		Part Number:	D3785-3
Inspection Dwg: D3785	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.001	1		VDC-01	
6.750	+/-0.010	6.751	1			
8.500	+/-0.010	8.502	1			
9.927	+/-0.010	9.928	1			
0.203	+/-0.010	0.203	1			
0.405	+/-0.010	0.409	1			
5.500	+/-0.010	5.502	1			
1.500	+/-0.010	1.503	1			
3.51	+/-0.030	3.514	1			
3.134	+/-0.010	3.136	1			
2.259	+/-0.010	2.260	1			
1.435	+/-0.010	1.438	1			
1.255	+/-0.010	1.257	1			
1.427	+/-0.010	1.428	1			
Ø0.391	+0.006/-0.001	Ø0.391	1			
Ø0.201	+0.005/-0.001	Ø0.203	1			
0.080	+/-0.010	0.078	1			

Measured by:	SC
Date:	18/03/17

Audited by:	EB
Date:	MAR 29 2018

Preliminary Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	10.02.02	Dimensions revised per Dwg Rev D	KJ	
C	10.08.03	Dwg Rev updated	KJ	

DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>175018</u> Part No. <u>D 3785-3</u> NCR No. <u>19-7752</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☒ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☒ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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